

**Work Order ID 53959**

November 23, 2009 3:40:21 PM



Page 1

Item ID: D4015-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearbar

Start Date: 11/23/2009 Start Qty: 60.00



Cust Item ID:

Required Date: 12/2/2009 Req'd Qty: 60.00



Customer:

Reference:

Run Start

Approvals: Process Plan: mf Date: 09-11-23 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4015	B
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100 0.00



Waterjet

0.00

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D4015

Dwg Rev: BProg Rev: B

2-Deburr if necessary

110 0.00

QC



QC

Quality Control

Memo

QC2- Inspect parts off machine FAI/FAIB

0.00

B 9-11-269/509/2/0293B 9-11-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Stop



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Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00	27 Sor12/02			counter (493)	✓		
130  Brake NC Brake NC	Form as per dwg  Memo ***Use DT9541 forming tool***	0.00  0.00	88 09/12/07			93	✓		
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00	27 Sor12/02			counter (893)	✓		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

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Item ID: D4015-1

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Revision ID:

Item Name: Wearbar

Start Date: 11/23/2009 Start Qty: 60.00

Required Date: 12/2/2009 Req'd Qty: 60.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

Identify as per dwg & Stock Location: 139

0.00



Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/08 (93)09/12/08 *JA**mc*  
09-12-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 53959



Parent Item: D4015-1

Parent Item Name: Wearbar

Start Date: 11/23/2009

Required Date: 12/2/2009

Comments: IPP RevA: New issue 09.10.28 verified by:JLM  
remove welding 09.11.03 DD verified by:EC  
dwg 09.11.18 DD verified by:JLM

IPP Revb:  
IPP RevC: revC as per

Start Qty: 60.00

Required Qty: 60.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
M304S16GA		Purchased	No			100	sf	81.8637	0.6000	1.		



304/316 Sheet .063



185-11-20

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
MAT	81.86367369	
106860	16.018	
111924	25.1689737	
112442	29.8899	
112567	0.2973	
112885	10.4895	

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
112885

93

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

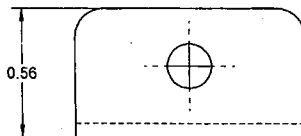
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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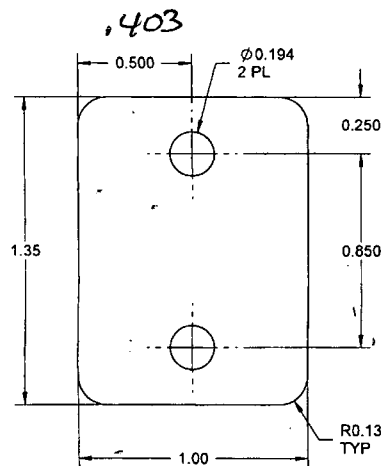
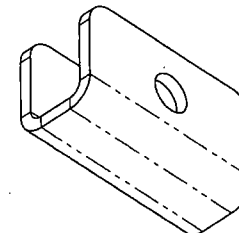
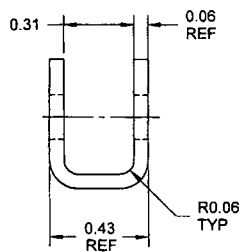
**NOTE:** Date & initial all entries







**D4015-1 WEARBAR**  
MAKE FROM D4015-1



**D4015-1F WEARBAR FLAT PATTERN**

#53959

**RELEASED**  
2009-11-24

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)  
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240  
REF. DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. B
MFG. APPR.	DS	D4015	SHEET 2 OF 2
APPROVED	WD	TITLE	SCALE
DE APPR.	W	WEARBAR WELDMENT	NTS
DATE	09.11.13	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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